

# Work Order ID 58945

Thursday, May 20, 2010 10:32:13 AM

Page 1

Item ID: D2221

Accept

Setup Start

Revision ID:

Stop

Item Name: 350 Basket Base

Start Date: 5/25/2010 Start Qty: 1.00

Required Date: 6/8/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan: *[Signature]* Date: *10/5/08* Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								
100	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221 3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S. Rod Batch: <i>11/3328</i>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

*[Signature]* 10/06/08 (1x)

*[Signature]* 10.06.08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Run

Start



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to M14841

1ST COAT:  
START TIME: 10:45  
OVEN TEMPERATURE: 400°  
FINISH TIME: 11:15

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:  
START TIME: \_\_\_\_\_  
OVEN TEMPERATURE: \_\_\_\_\_  
FINISH TIME: \_\_\_\_\_

① BK 10-6-30

① BK 16-6-30

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

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140 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							
150 	Identify as per dwg & Stock Location: <u>G-A</u>	0.00							
Packaging Packaging	Memo <u>w/o 58941</u>	0.00							
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

*5/20/07/05 @*

*5/20/07/05 @*

*5/20/07/05*

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# Picklist Print

Thursday, May 20, 2010 10:32:17 AM

Page 1 / 4

Work Order ID: 58945

Parent Item: D2221

Parent Item Name: 350 Basket Base

Comments:

IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 5/25/2010

Start Qty: 1.00

Required Date: 6/8/2010

Required Qty: 1.00

✓ D2221-1 Manufactured No 100 Each 23.0000  
 Rib

Location	Loc Qty	Loc Code
WA	23	
57182	1	
57499	10	
58122	12	

✓ D2221-5 Manufactured No 100 Each 16.0000  
 Rib

Location	Loc Qty	Loc Code
WA	16	
57500	8	
58027	8	

✓ D2221-7 Manufactured No 100 Each 8.0000  
 Rib

Location	Loc Qty	Loc Code
WA	8	
57501	4	
57805	4	

✓ D2232-3 Manufactured No 100 Each 14.0000  
 Basket Hinge

Location	Loc Qty	Loc Code
WA	14	
57502	8	
57793	6	

1 B528 SJ 10/06/21  
 ①  
 2 SJ 10/06/21  
 ②  
 1 SJ 10/06/21  
 ①  
 2 B59264 ② SJ 10/06/21

W/O:		WORK ORDER CHANGES					
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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 5/25/2010

Start Qty: 1.00

Required Date: 6/8/2010

Required Qty: 1.00

✓ D2235-1 Manufactured No 100 Each 12.0000  
 Basket Rib

Location	Loc Qty	Loc Code
WA	12	
57593	2	
57792	10	

B59267 @ 10/06/21

✓ D2581 Manufactured No 100 Each 44.0000  
 Mounting Bracket

Location	Loc Qty	Loc Code
WA	44	
46086	2	
51745	2	
57185	1	
58301	19	
58687	20	

B59121 @ 10/06/21

✓ D3442-1 Manufactured No 100 Each 28.0000  
 Shim

Location	Loc Qty	Loc Code
WA	28	
56579	16	
58028	12	

10/06/21

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Shop Packet Print

Page 2

W/O:

## WORK ORDER CHANGES

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 5/25/2010

Required Date: 6/8/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3825-041 Manufactured No 100 Each 8.0000  
 Rib Assembly (Basket End)

Location	Loc Qty	Loc Code
WA	8	
57401	2	
58025	6	

B58998 ② 10/06/21

✓ D3826-041 Manufactured No 100 Each 8.0000  
 Rib / Gusset Assembly

Location	Loc Qty	Loc Code
WA	8	
57432	2	
57835	6	

B58981 ② 10/06/21

✓ D3827-041 Manufactured No 100 Each 10.0000  
 Rib Assembly (Inboard)

Location	Loc Qty	Loc Code
WA	10	
57219	4	
57802	6	

B59276 ① 10/06/21

✓ D3832-1 Manufactured No 100 Each 6.0000  
 Mesh (Base)

Location	Loc Qty	Loc Code
WA	6	
57791	3	
58165	3	

B59341 ① 10/06/28

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Shop Packet Print

Page 3

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Page 4

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IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3833-1 Manufactured No 100 Each 9.0000 2



Mesh (Base End Face)



B59184 ② SJ 10/06/28

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	9	
56396	1	
57834	8	

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Shop Packet Print

Page 4

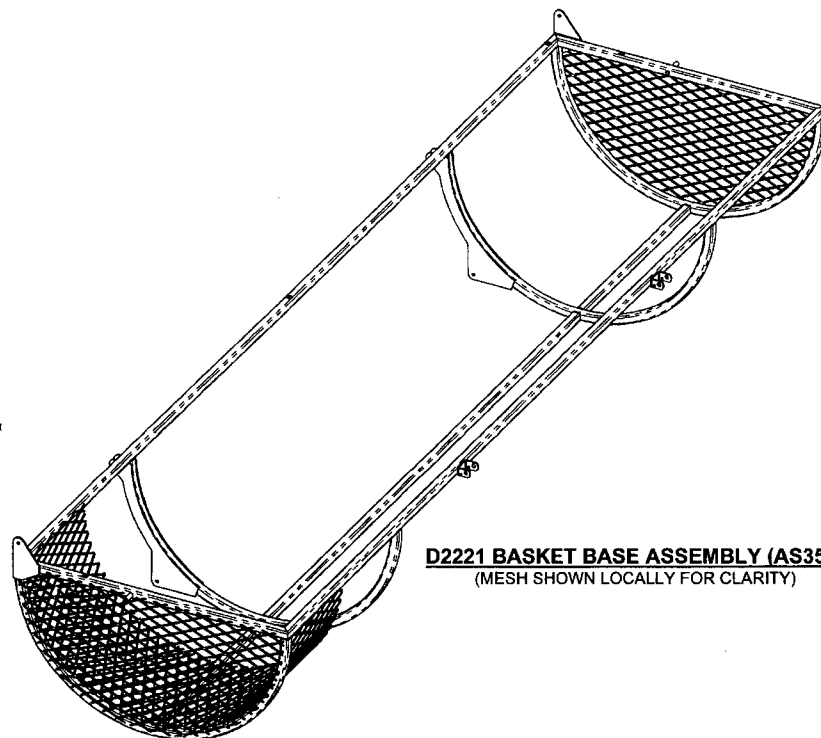
**Dart Aerospace Ltd**

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**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**






- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38945

*210-5-20*

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

**RECEIVED**  
*08/11/18*

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.		MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT		AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET		PH	05.08.07
E	CHANGE HINGE		CP	01.04.19
D	CHANGE LATCH		BW	96.06.21
C	SEPARATE BASKET AND LID		KH	95.11.21
REV. I	DESCRIPTION		BY	DATE
DESIGN	BW	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. H	
MFG. APPR.		D2221	SHEET 1 OF 5	
APPROVED		TITLE	SCALE	
DE APPR.		BASKET BASE ASSEMBLY (350)		
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

**Dart Aerospace Ltd**

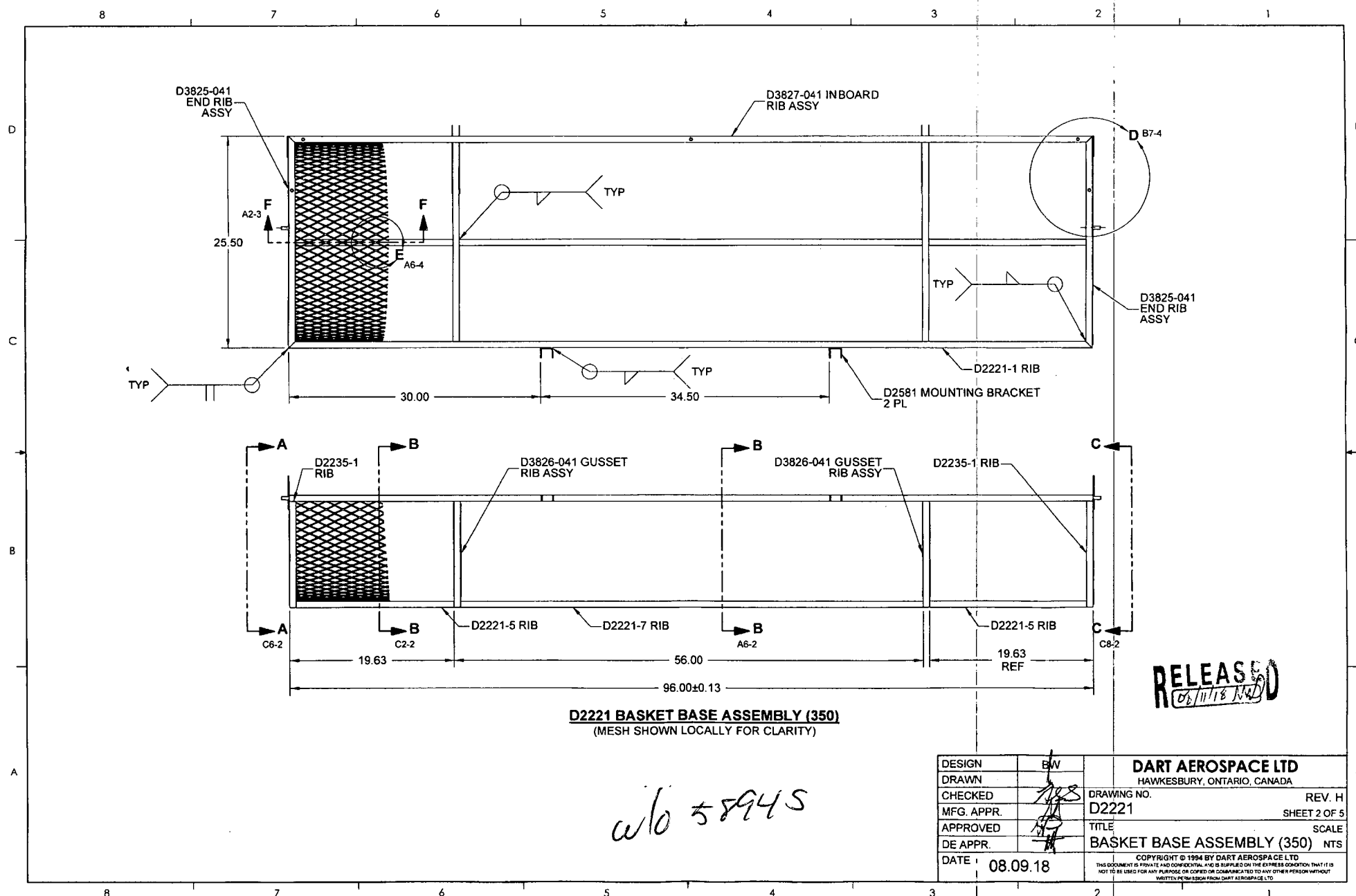
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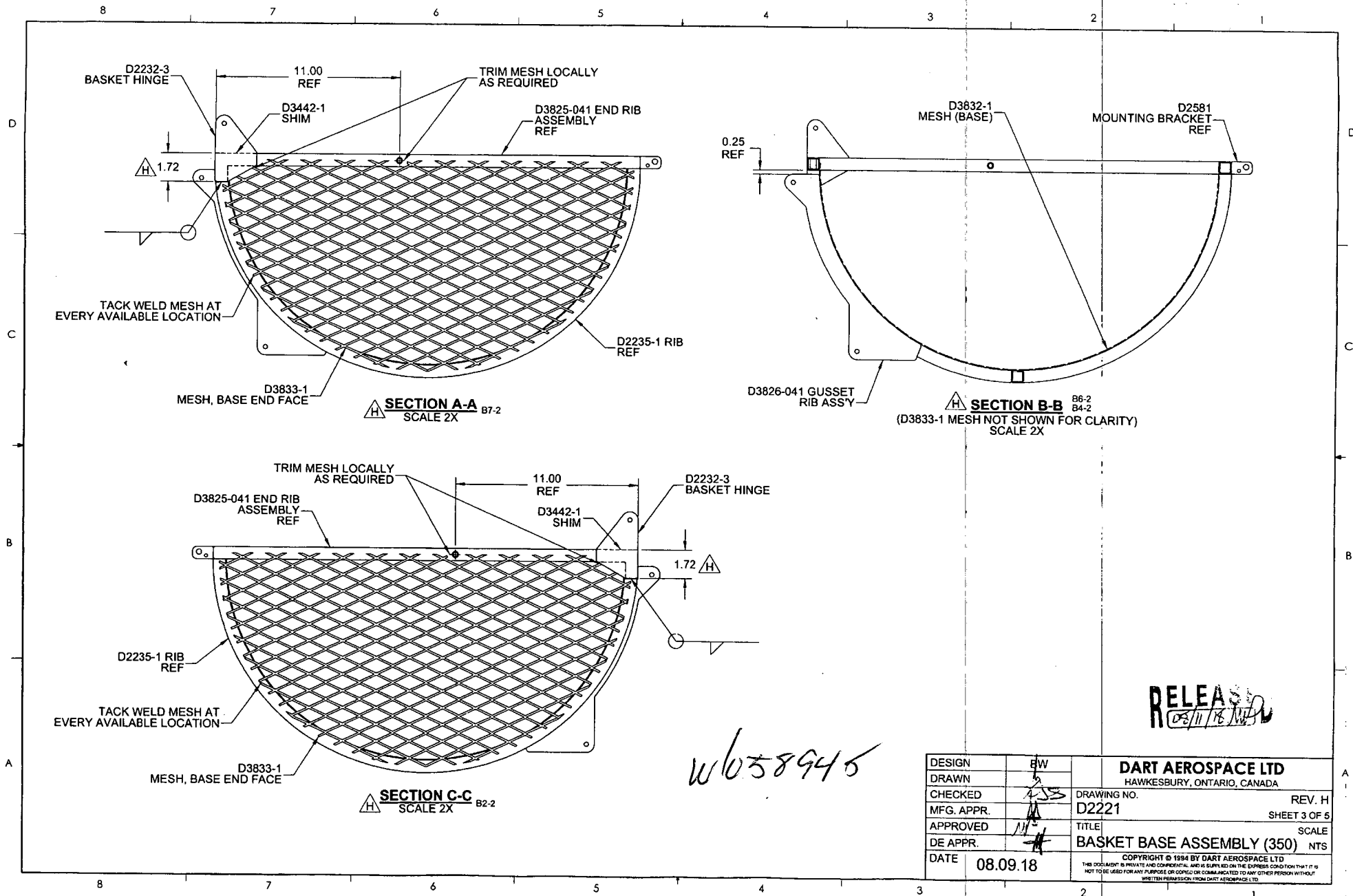
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RELEASED  
03/11/18

DESIGN	FW	DART AEROSPACE LTD	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	433	DRAWING NO.	REV. H
MFG. APPR.	11	D2221	SHEET 3 OF 5
APPROVED	11	TITLE	SCALE
DE APPR.	11	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

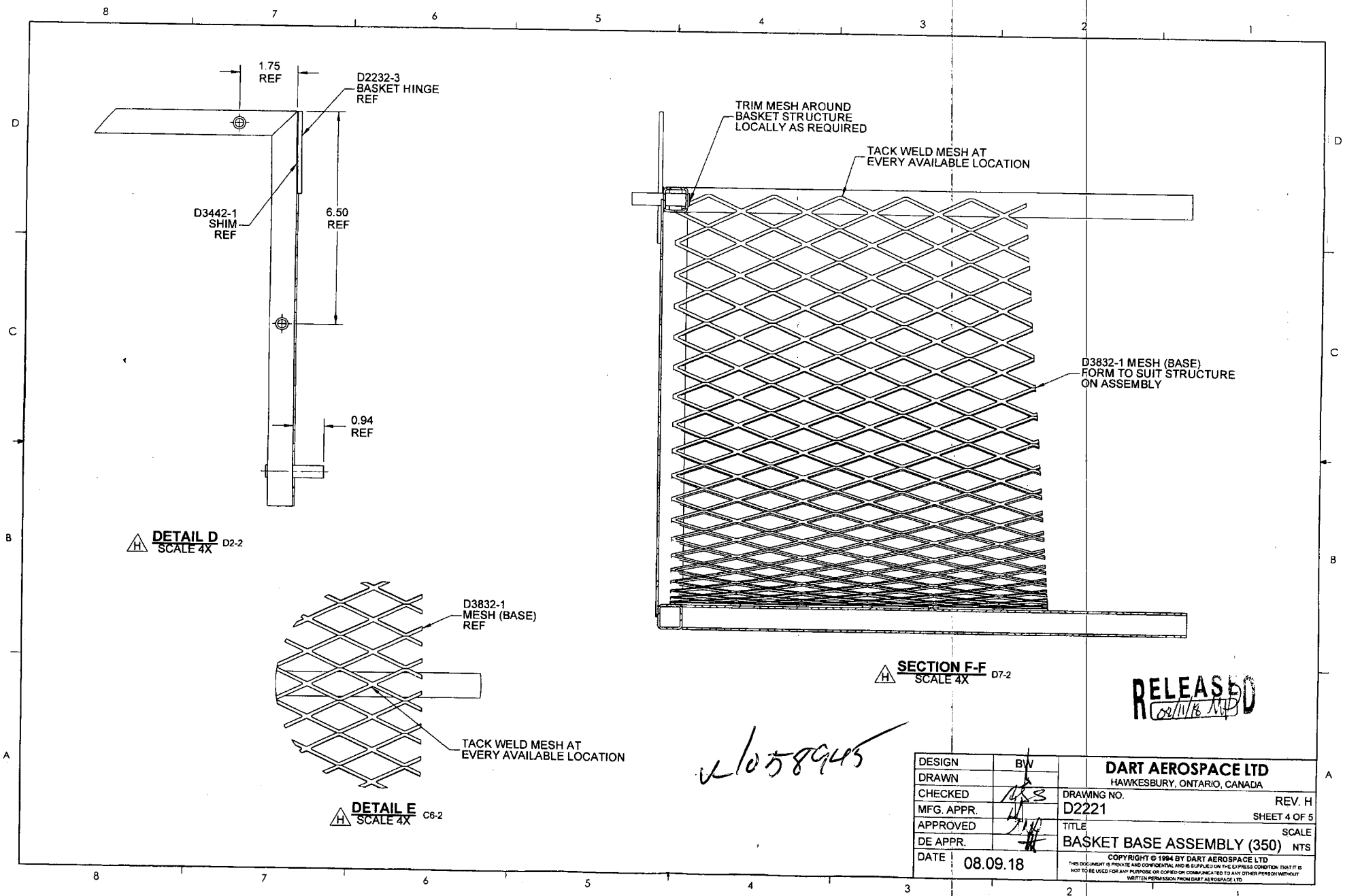
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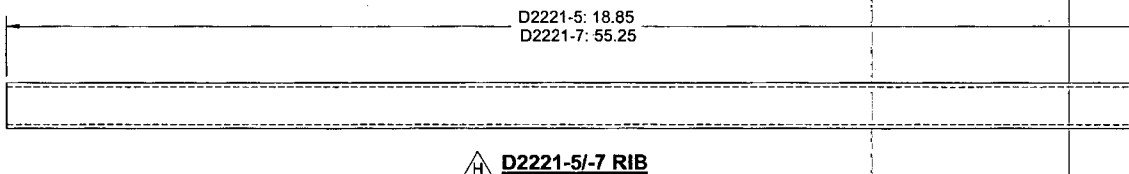
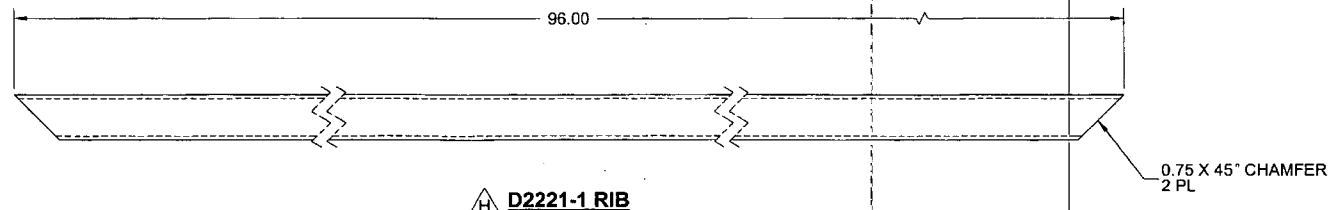
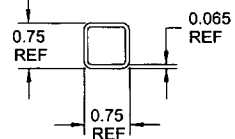
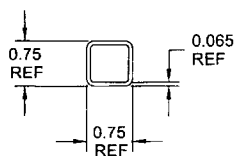
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*u/c 58715*

**RELEASED**  
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ADS	DRAWING NO.	REV. H
MFG. APPR.	MS	D2221	SHEET 5 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	SH	<b>BASKET BASE ASSEMBLY (350)</b> NTS	
DATE	08.09.18	COPYRIGHT © 1984 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries